

Date: Monday, 4/23/2007 1:52:35 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 31992		
Estimate Number	: 12731		
P.O. Number	: <i>N/A</i>	Part Number	: D353535
This Issue	: 4/23/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3535 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: <i>X B</i> <i>PH 07.04.26</i>
Previous Run	: 30751	Material	: <i>N/A</i>
Written By	:	Due Date	: 4/30/2007 Qty: <i>26</i> Um: Each
Checked & Approved By	: <i>PH 07.04.26</i>		
Comment	: Est Rev:A New Issue 07-02-15 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.8423 sf(s)/Unit Total : 16.8462 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: *M101823*

SAD 07/04/30

26

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: *B*

Prog Rev: *B*

SAD 07/04/30

26

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/04/30

26

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SB 07.05.01

26

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Deburr if necessary

2-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.

3-Identify as D3535-35.

SB 07/05/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: A Date: 07/05/04

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:52:35 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 31992

Part Number: D353535

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/02 (26)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M101601

07-05-03 (26)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 07/05/04 (26X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

EP-15

M-L 07/05/04 (26X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/04 (26)

Job Completion



07-05-04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

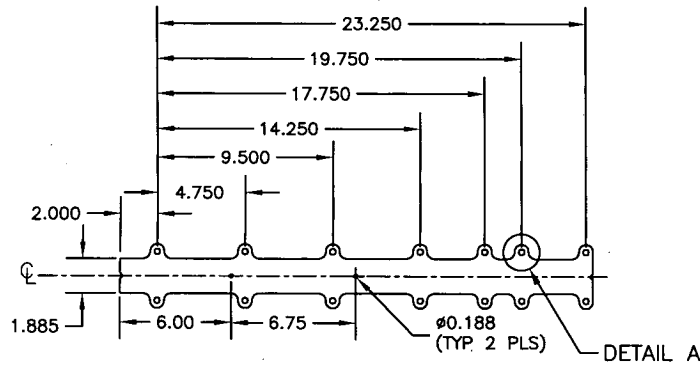
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

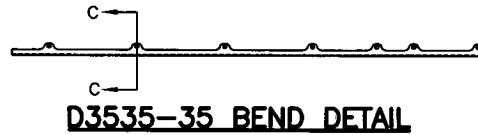
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

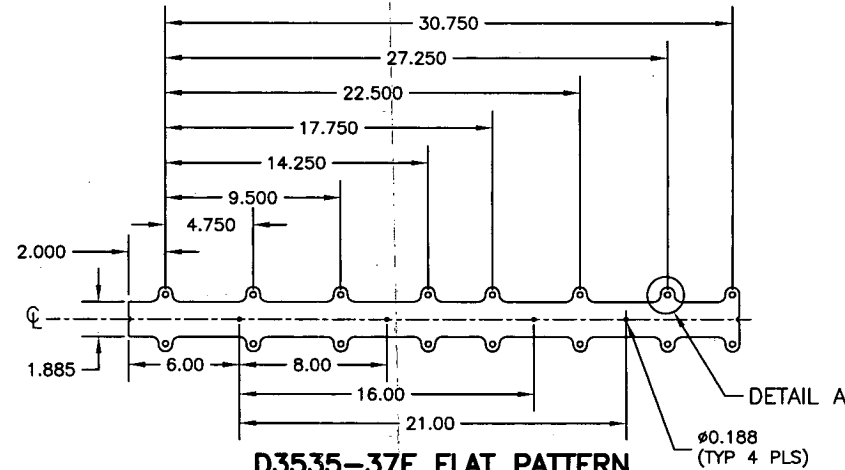
PRELIMINARY ISSUE



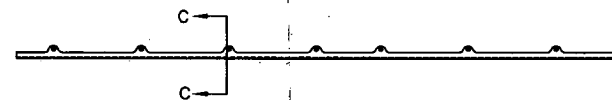
D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

NOTES

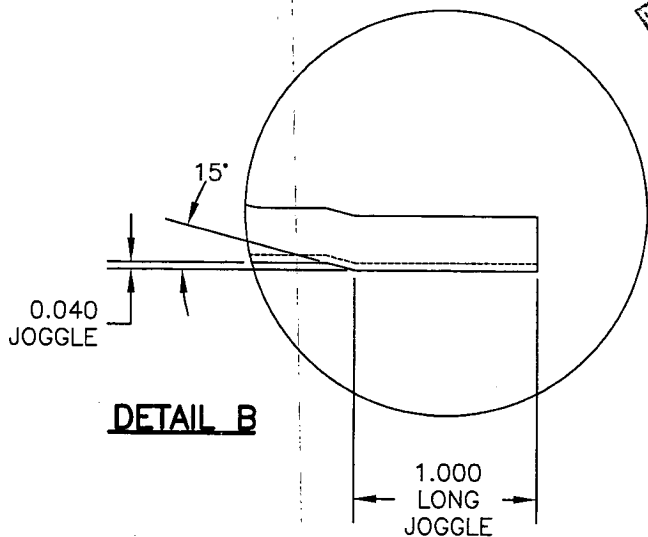
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31992

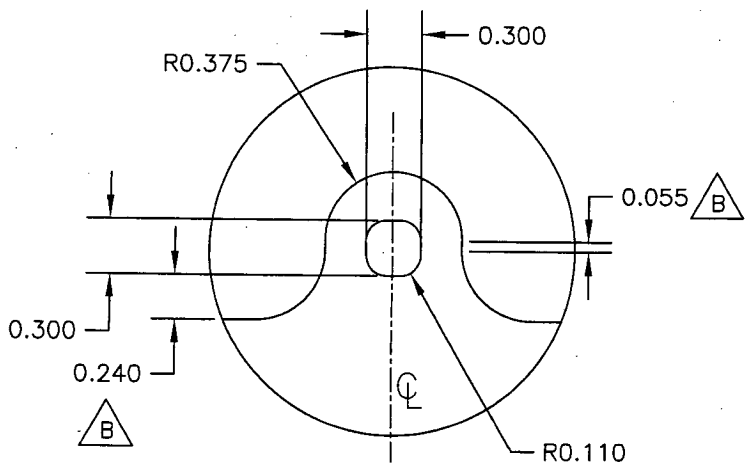
DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3535	REV. B
DATE 07.04.17	TITLE WEARSHOE	SHEET 5 OF 7	SCALE 1:10

PRELIMINARY ISSUE

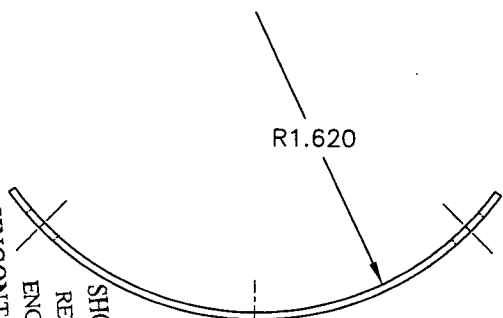
DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3535	REV. B
DATE 07.04.17		TITLE WEARSHOE	SHEET 7 OF 7
		SCALE 1:1	



DETAIL B



DETAIL A



SECTION C-C

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WITHOUT NOTICE

WORK ORDER
NO. 31992

DART AEROSPACE LTD		Work Order: 31992
Description: WEAR PLATE		Part Number: D353535
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 2.000	+/- 0.010	2.007	✓		Vern	
B 1.885	+/- 0.010	1.887	✓		Vern	
C 6.00	+/- 0.030	6.01	✓		Vertical Vern	
D 6.75	+/- 0.030	6.754	✓		Vern	
E Ø0.188	+0.005 -0.001	Ø0.190	✓		Vern	
F 23.250	+/- 0.010	23.250	✓		M-T	
G 19.750	+/- 0.010	19.750	✓		M-T	
H 17.750	+/- 0.010	17.750	✓		M-T	
I 14.250	+/- 0.010	14.250	✓		M-T	
J 9.500	+/- 0.010	9.500	✓		Vern	
K 4.750	+/- 0.010	4.752	✓		Vern	
L Ø.360	+/- 0.010	0.296	✓		Vern	
M 0.300	+/- 0.010	0.296	✓		Vern	
N 0.038	+/- 0.010	0.036	✓		Vern	
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAD	Audited by: BG	Prototype Approval:	N/A
Date: 07/04/20	Date: 07-05-21	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	